Mitchell's Mausers

Owner's Manual

For the Care and Use of the

Mitchell Gold Series

.45 ACP, .40 SW, and 9 mm

1911 Automatic Pistols

Made in USA

This instruction manual should always accompany the pistol and be transferred with it upon change of ownership. Become thoroughly knowledgeable with the instructions contained here and review the entire booklet each time you intend to use your pistol.

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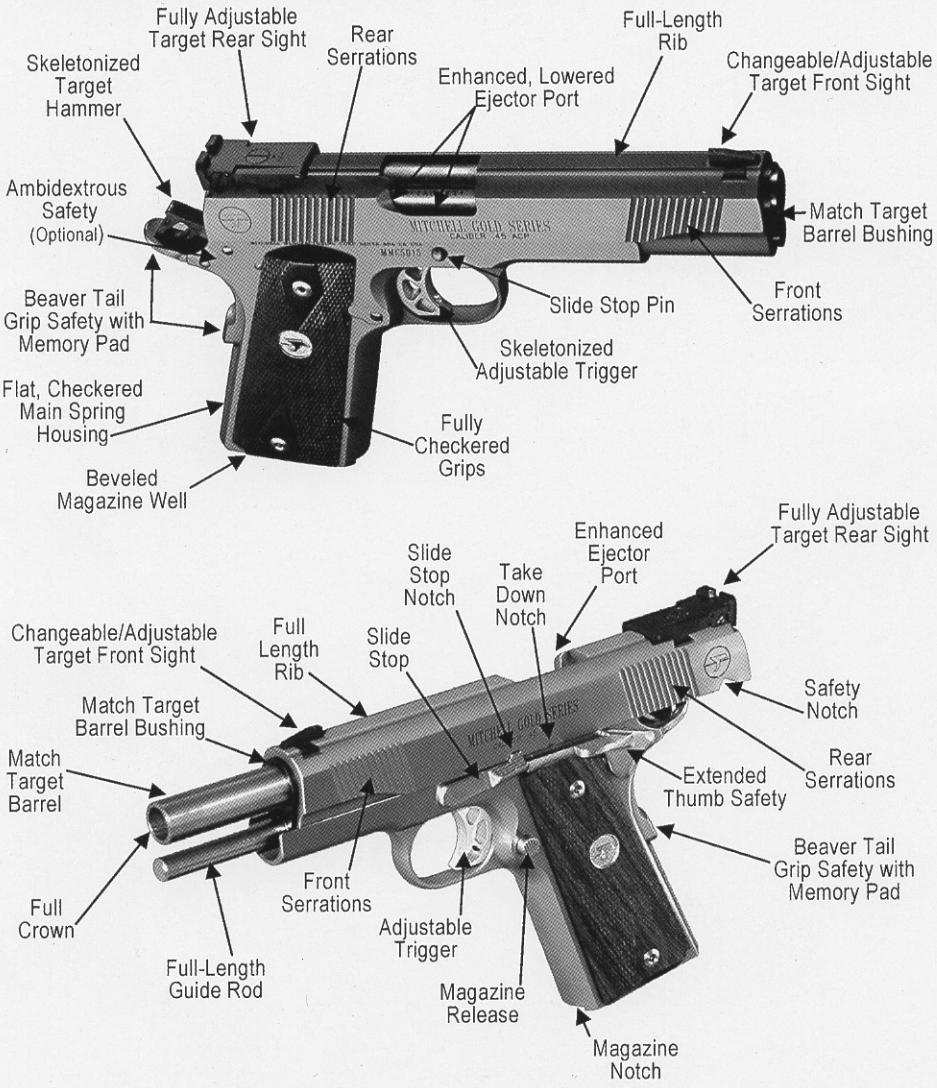

Feature Diagrams of the .45 ACP Gold Series

The Mitchell Manufacturing .45 Auto is The Next Generation version of the original US Army .45 Auto. It retains the original internal 1911 action and is combined with 21st century enhancements. Made in blued steel or stainless steel with no plastic parts.

Ambidextrous safety (optional extra).

Congratulations . . . .

Congratulations on your purchase of one of the most famous of all designs in the fascinating world of firearms. Few other products, of any type, have a silhouette as recognizable as the world famous ".45 automatic".

Produced in Stainless Steel or Blued Steel, this is Mitchell's highly advanced version of the original Colt Government Model known now as the Gold Series.

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Introduction

As a responsible firearms owner, you must read this Owner's Manual thoroughly and become completely comfortable with it before you handle your pistol. Then examine your pistol carefully after you've read this manual and make sure you understand all of the basics associated with it.

Your pistol is as well made as modern technology allows and will give you a lifetime of reliable service, security, and pride of ownership. You, the owner, must use it intelligently, keep it clean, and call us with any questions.

A Brief Model Background

The ancestry of the .45Auto goes to its original source/designer, John Browning, who recognized the desire of the US Army to move from double-action revolvers to semi-automatic pistols. This took place around the turn of the 20th century. The gun was finally adopted by the US Army in 1911. Hence the name, Model 1911, then later the 1911A1, and sometimes known as the Government Model 1911.

Originally, the pistol was designed for military service, which demanded reliability as a primary requirement, and accuracy was secondary.

Today, the Mitchell Gold Series .45 Auto utilizes advanced design techniques, modern metallurgy, and computer controlled manufacturing to achieve performance that John Browning could only dream of. Added are the many feature enhancements described for you in this Owner's Manual which give you accuracy and reliability, and make your new pistol far more versatile than any predecessor model. After all, you can expect more because it has been basically the same for 93 years, until we enhanced it.

General Features

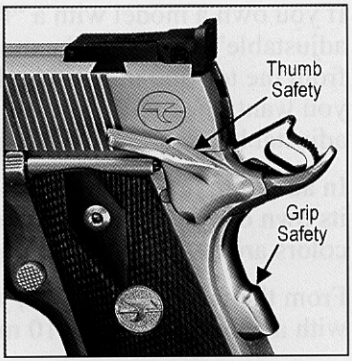
The Mitchell Gold Series Auto, available in 3 calibers, is a magazine-fed, recoil-operated, closed-breech, inertia-fired, single action, semi-automatic pistol. All model variations are a part of the Mitchell Gold Series.

The pistol rests naturally in the hand by virtue of its distinctive shape and grip angle. It thus becomes natural to draw, natural to point, and is very accurate. In all of its models, it has many assets and many new features; but perhaps its most endearing attributes are enduring reliability, operating simplicity, and now, accuracy; the best ever!

Safety Features

The Mitchell Gold Series .45 has **three basic safety systems**; one is passive, two are active. The passive safety is the inertial firing pin. The firing pin will not normally reach the cartridge primer unless the pin is struck by the hammer. You can do that by, of course, pulling the trigger! The active safeties include the **grip safety** and the **thumb safety**. The grip safety, located in the upper-rear part of the frame, is

designed to recognize whether or not your hand is properly holding the gun for firing. In the act of holding the gun, you naturally depress (push in) the grip safety. Do not defeat this valuable safety mechanism. If you have not gripped the gun properly, or if you drop the gun with the hammer cocked, this safety is intended to prevent the hammer from falling and firing the gun!
DO NOT DEFEAT THIS SAFETY MECHANISM!!!



Separately, the thumb safety will, when you push it upward firmly to its uppermost position, lock the slide shut, with the hammer cocked. With the hammer down, the pistol is "safe", because you can't shoot it unless you manually function the slide or manually (deliberately) cock the hammer. Remember; one safety is passive, the firing pin normally will not reach the primer until properly struck by the hammer. Two are active; the thumb safety, which you apply manually, and the grip safety, which you naturally apply when you hold the gun correctly.

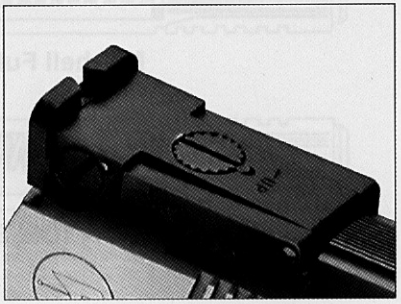
In spite of the best safety systems:
Any gun can potentially discharge if it is dropped or bumped.

Do not chamber a round until you are ready to shoot!

The number one safety is you, the owner. Nothing here is a substitute for good common sense, so use it!

Sights

There are two sight systems available, depending on the model you have purchased. One system includes a fully adjustable rear sight; adjustable for both windage and elevation, by simply turning the adjusting screws either up or down or left or right as needed. Adjusting the point of impact of your .45 is easy. Directional arrows on the sight indicate how to adjust the bullet impact point.



Adjusting the windage screw clockwise, to the right, will move the bullet impact point to the left. Adjusting the elevation screw clockwise, to the right, will move the bullet impact point downward. Your sights are easy to adjust.

If you own a model with a "fixed" rear sight you will find that it is "drift-adjustable", i.e., it can be moved left or right by loosening the screw in it from the top and moving in the direction as described above for the results you want; then re-tighten the screw to lock it in place. Elevation is not adjustable on the "fixed" rear sight, it is "designed-in".

In addition, the front sight in either model is easily replaceable. It is fitted in its own dove-tail notch in the front of the slide. Many different styles and colors are available as optional accessories.

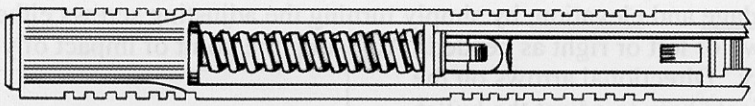
From the factory test range, your pistol is sighted to "impact" dead-center with a 6 o'clock hold at 10 meters.

The Slide

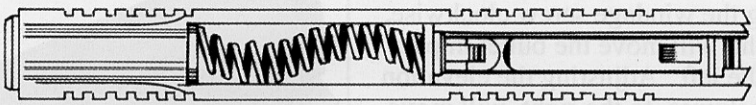
The slide is new and unique in that it contains many enhancements. The slide has target-type serrations at the rear and the front on both sides. It also has a full-length rib, which houses the front and rear sights. Further, the slide is fitted with a very close tolerance barrel bushing that locks the muzzle of the barrel tightly to the slide; thus forming a solid steel lock-up between the barrel, the slide, and the sights! This is a great enhancement to accuracy.

Full Length Guide Rod

Just below the barrel is a new style full length guide rod specially designed for smooth action; designed to keep the recoil spring guided throughout the firing cycle, to not interfere with barrel action during recoil. It is very special and enhances a smoothly functioning pistol. Shown here is a comparison of the old style and the new Mitchell full-length guide rod.



Mitchell Full Length Guide Rod



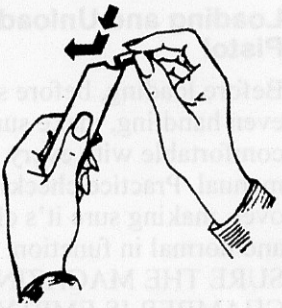
Ordinary (Old Style) Recoil Spring System

The Barrel

It is a very special close-tolerance barrel, mated closely to the slide and its barrel bushing to give superior accuracy. It is far "tighter" than standard military handguns and it will not tolerate mud, dirt, sand, etc, so you must keep your pistol clean and lubricated. The breech of the slide and the hood of the barrel are closely fitted; matching the fit of the barrel, its bushing and the front of the slide. Accuracy is dramatically improved and stays that way.

The Hammer

It is a specially designed, skeletonized target/combat hammer with sharp serrations. It is a high quality, clean-breaking hammer, designed to stay that way! The hammer retains the traditional half-cock notch designed to "catch" the hammer if your finger should slip off during manual cocking or de-cocking.



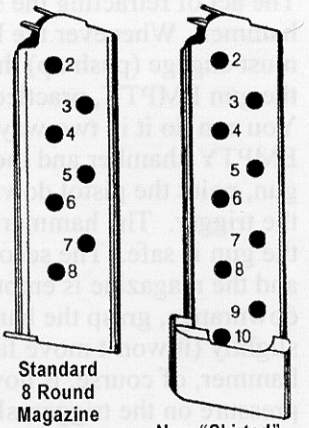
The Cartridge-Counter Magazine

Your pistol comes with a stainless steel, 8 round capacity magazine with a patented split-follower. Capacity markings are indicated on both sides of the magazine with all cartridges visible, no matter how many you've loaded.

Load your magazine, one cartridge at a time, (DON'T USE SPEED-LOADING DEVICES) up to 8 rounds. Load the cartridge, base first, starting at the front edge of the follower and slide the cartridge under the lips. Do that each time.

YOUR PISTOL WILL FIRE WITHOUT A MAGAZINE IN IT, as an emergency feature for you, should you lose or damage your magazine. You must be careful when you remove a magazine, for this very reason, to insure the chamber is empty too!

A special 10 round magazine is available for your pistol. As it extends below the base of your pistol, the magazine extension is protected by a wrap-around skirt. It fits your pistol as well as the standard 8 round model, but gives you two extra rounds!

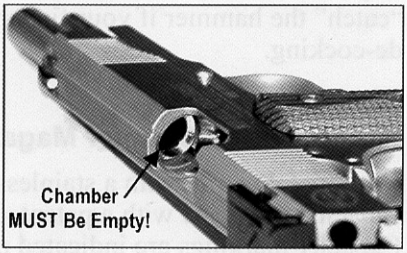


Standard 8 Round Magazine

New "Skirted" 10 Round Magazine

The Frame

The frame is all stainless steel (or blued, depending on the model you bought) and contains several design enhancements. The trigger guard is designed with a classic curvature including an undercut relief at its rear to allow a "high hold" on the gun. The beavertail extension is nicely fitted and accepts the fast-action hammer without any difficulty or binding. The frame is considerably advanced over standard .45 Auto pistols by virtue of being exquisitely machined and finished to provide a "high hold", bringing your hand close to the centerline of the bore. This helps you recover from recoil easily and quickly. It is made to take the advanced Mitchell target barrel design with its wide smooth feed ramp. The magazine entry well is beveled on its edges to facilitate quick magazine changes. Old military barrels and bushings are just that, old, and they won't fit your Mitchell nearly as well as our new parts.



Loading and Unloading Your Pistol

Before loading, before shooting, before even handling, make sure you are comfortable with every aspect of this manual. Practice checking your pistol over, making sure it's clean, complete, and normal in function. Check the pistol to make sure it is empty. MAKE SURE THE MAGAZINE IS EMPTY AND MAKE SURE THE CHAMBER IS EMPTY. Cycle the slide by hand several times to make sure it moves smoothly and without hesitation. Be certain the slide stop operates normally. Be sure the slide goes fully forward under its own power.

The act of retracting the slide "cocks" the hammer. Whenever the hammer is cocked, you must engage (push up) the thumb safety. With the gun EMPTY, practice lowering the hammer. You can do it in two ways. First, with an EMPTY chamber and the magazine out of the gun, point the pistol down-range and simply pull the trigger. The hammer will fall normally and the gun is safe. The second way (after making sure the chamber is empty and the magazine is empty and out of the gun) is to point the pistol downrange, grasp the hammer firmly with your free hand and retract it slightly (it won't move far) and while doing so, pull the trigger. The hammer, of course, is now free to fall, but you are holding it back. Keeping pressure on the trigger, slowly lower the hammer to its full down position. If you lose your grasp of the trigger during the process, the hammer will be caught halfway down by the half-cock notch built into it. If that happens,

keep the pistol pointed downrange and simply re-cock the hammer. Keep doing it with an empty gun until you get it right and are completely comfortable with it.

Now, to load your pistol, you first load the magazine using only the correct caliber cartridges as shown in the earlier magazine section. Then you insert the magazine into the magazine well. You can't do it wrong; it will go in only one way. Simply push (don't slam) the magazine all the way into the well. "Slamming" the magazine, like they do it in the movies, is the wrong way. Remember, they are shooting blanks! You are using the real thing.

You can insert the magazine into the gun with the slide locked back or fully forward. If the slide is neither fully forward, nor locked back, SOMETHING IS WRONG, so check it out. Empty the gun totally, including the chamber, and find out why. Fully check the slide function, and the hammer, and the trigger before proceeding again.

With a loaded magazine inserted, you are holding a loaded gun, so keep it pointed downrange. If the slide is not already back, grasp the slide firmly by the serrations with your free hand and retract it fully. This takes some little energy on your part, so retract it smartly. When it is fully to the rear, relax your grasp on the serrations and allow the slide to snap forward under its own force; don't lower it slowly. When the slide closes, it will have stripped a cartridge from the magazine and loaded it into the barrel chamber. The gun is now loaded and the hammer is cocked and it is ready to fire! You should be holding the gun firmly and pointed downrange. The gun is live and ready to fire. Keep your finger out of the trigger guard and engage the thumb safety (push it up fully).

Shooting

With your loaded gun "on safe" and pointed downrange, the gun is ready and you've got to be certain you are ready and alert. You must know where your bullet is going when you pull the trigger. You are shooting a powerful cartridge capable of satisfyingly high performance. As such, you must be certain of the backstop when you hit your target. At the same time, you must know where the bullet is going if you miss. This is ordinary common sense!

Proper Form: When you align the sights on your target, you must form a sight picture, which looks like this. Nothing else is acceptable; this is the sight picture you must get for every shot. One eye open or two eyes open, your choice. Keep your finger out of the trigger guard. Gripping the pistol properly will naturally depress the grip safety (as it should). Stand facing your target with the pistol fully extended in front of you, align the sights on the target, as

above. Push the thumb safety down with the thumb of your shooting hand. Then, and only then, put your finger on the trigger. If you wish, you may support your shooting hand by "cupping" your other hand under the bottom of the pistol hand, wrapping your fingers lightly around the back of the shooting hand. Good form is to support it, don't squeeze it. Keep the thumb of the shooting hand lightly pressing down on the thumb safety.

Your pistol has a very light, clean breaking trigger and it is sensitive to your finger, as it should be. With the sights aligned, proper stance, safety off, backstop assured, put your finger on the trigger, and when comfortable, press the trigger. Each time the gun fires, the slide recoils, ejects the fired round (during the rearward motion), strips a fresh cartridge from the magazine and closes it into the barrel, ready for the next trigger pull. It will continue to do so for each separate trigger pull or until the magazine is empty.

When the magazine is empty, the slide will be locked open, ready for you to remove the empty magazine and insert a fresh one. When you do so, you then close the slide by pushing down on the slide stop (which is holding the slide open). This takes a little force because the slide is pressing hard against its stop; it wants to close. When you press down on the slide stop, expect the slide to snap forward (close) smartly. In doing so, it loads the gun again because it strips a fresh cartridge from the magazine and into the barrel. BE ALERT. The safety is off, the gun is loaded, the hammer is cocked, the gun is ready to fire, and you may safely continue.

After last round, slide locks open.

IF YOU CHANGE YOUR MIND AND CHOOSE NOT TO SHOOT, take your finger off the trigger, keep the gun pointed downrange, and push the thumb safety "on". Press the magazine catch and remove the magazine. You still have a loaded round in the chamber! Now, keep the gun pointed downrange, keep your finger out of the trigger guard and push the safety down or "off". Grasp the serrations on the slide and retract the slide smartly. This will eject the live round from the chamber. Holding the slide back, look through the ejection port directly into the chamber and make sure it is empty. After you are sure, you may let go of the slide and allow it to close by itself. Now, lower the hammer as described earlier. Empty the magazine manually, (while it is out of the gun), insert it into its magazine well and the gun is now empty and safe. You, of course, may then resume shooting at the time of your choice. You should practice as often as you can to stay proficient. **Re-read this manual often, especially if a significant amount of time passes between your shooting sessions.**

Cleaning and Maintenance

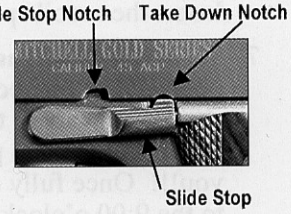
Very little is required of you, but you must keep your gun clean and lubricated. It is made of stainless steel to guard against rust, but it is still steel, and steel parts need lubrication.

Before you take-down your pistol for cleaning, you will, of course, be certain it is empty. In doing so, you must remove the magazine AND DOUBLE CHECK THE CHAMBER FOR LIVE ROUNDS.

Slide and Barrel Removal

To disassemble the barrel/slide assembly, proceed as follows, but be careful. This assembly is under tension and requires your undivided attention. The recoil spring is contained in, and guided by, the full-length guide rod. Its tension must be relaxed and the guide-rod assembly dismantled in order to remove the barrel. It is easy to do but requires care in handling.

1. Make sure the gun is unloaded and the magazine is out. Make sure the chamber is empty.
2. Make sure the hammer is down and the slide is forward.
3. **Wearing clear shooting glasses**, use a 'bushing wrench' or simply a small piece of wood to depress the recoil spring cap that protrudes just below the muzzle of the barrel. While depressed, turn the barrel bushing clockwise, roughly to the 9:00 o'clock position (as you face it). **THE RECOIL SPRING CAP IS UNDER GREAT PRESSURE** so you must slowly allow it to come forward and slowly relieve its tension. Remove the cap and the spring.
4. Cock the gun and move the slide to the rear until the semi-circular take down notch in the slide aligns with the slide stop catch.
5. Remove the slide stop by applying finger pressure to the slide stop pin from the right side and then lifting it out from the left side.



6. Pull the slide and barrel assembly forward off of the frame.
7. Remove the guide rod by lifting it out of the inverted slide.
8. Rotate the barrel bushing in the opposite direction as far as it will go and pull it out.
9. Remove the barrel through the front of the slide.

The frame can now be easily cleaned and lubricated. No further dismantling of the frame assembly is required. A word of caution: do not "dry-fire" the

hammer/trigger in this condition; lower the hammer manually only, as described previously.

Once disassembled, you can easily clean all the parts with normal gun care equipment, readily available where you bought your Gold Series Pistol. Once clean, carefully lubricate all parts before re-assembly.

Replacing Barrel and Slide Assembly

1. Insert the barrel through the front of the slide all the way to the rear.
2. Place the barrel bushing over the barrel and fully into the front of the slide at the 4:30 position and turn it fully clockwise to the 9:00 o'clock position. The bushing has a small lug on it that fits in a groove in the front inside of the slide.
3. Insert the guide rod into the slide under the barrel with the small diameter end forward and the back 'forked end' straddling the barrel. The link must be rotated to the rear to provide clearance.
4. Holding the frame in its normal upright position, load the slide assembly onto the frame using the rails as a guide. Look through the slide-stop pin hole and see that the barrel link is lined up with the hole. Partially insert the slide stop and turn it to align with the front plunger on the left side of the frame (just above the left front of the grip). See picture on p.11. DO NOT SCRATCH THE FRAME.
5. Cock the hammer and retract the slide enough to now align the back end of the slide stop with the semi-circular notch in the slide. Push the slide stop all the way in. DO NOT SCRATCH THE FRAME.
6. Move the slide to the fully forward position and lower the hammer. Insert the recoil spring over the guide rod from the front.
7. **Wearing clear shooting glasses**, place the recoil spring cap onto the open end of the recoil spring. You must now compress the recoil spring and cap all the way into the slide. It is under great pressure so be careful. If you prematurely release it, it could go flying out and hurt you!!! Once fully depressed, turn the barrel bushing counter-clockwise to the 9:00 o'clock position, until the recoil spring cap snaps into place, locking the barrel bushing.

Once in place, you must manually retract the slide several times, allowing it to go forward under its own spring pressure. It must move freely, and fully, in both directions. If it doesn't, re-trace all your steps to find out why. If it doesn't seem right, call us. We're here to help. It is good practice to leave the magazine out of the gun when stored, just so you can tell at a glance, to know instantly that it is empty. **BUT, you must still check the chamber!** Never store a loaded magazine; it is simply un-safe, bad form and unprofessional to do so.

Service, Repair, Spare Parts

Your pistol is finely made and contains many enhancements over the old-style 1911's. Everything in your pistol is high grade in every respect. You should only use Mitchell-made replacement or spare parts, should your pistol ever need any service.

Mitchell Manufacturing recognizes its obligations to its customers and stands behind its product as it always has, and will continue to do so. Our products will be serviced free for a period of one year from the date of retail purchase to correct for any defects in materials or workmanship. Be sure to retain your sales slip as proof of purchase date if making a claim.

You should return the pistol to us for any service requirements beyond simply buying spare parts or accessories.

If you do return it to us for any reason, be sure the pistol is empty and include a letter describing any problem, together with your return address. Remember, we cannot return the pistol to anyone but you, the person who sends it to us, as mandated by federal law. Mitchell Manufacturing accepts no responsibility for damage or loss during shipping or transit.

You may buy spare parts and accessories from us, but parts should only be installed by a competent gunsmith who can assure fit and function.

Mitchell Manufacturing will not be responsible for any defects resulting from any unauthorized modifications or adjustments, improper or defective ammunition, abusive gun use, careless handling or corrosion.

Remember, once we build the pistol, check it, test it, approve it, record it, and legally ship it, we can no longer control it. As such, we cannot be responsible for any subsequent or consequential event with your pistol. It is, after all, a pistol, or firearm, as defined by US law, and full responsibility rests with you, its owner. It can give you a lifetime of shooting pleasure, security and competitive advantage over the old-style 1911's, and great pride of ownership. On the other hand, it can cause injury, property damage or death if abused, modified, mishandled or neglected.

Parts List

1. Barrel
2. Barrel Bushing
3. Barrel Link
4. Barrel Link Pin
5. Disconnector
6. Ejector
7. Ejector Pin
8. Extractor
9. Firing Pin
10. Firing Pin Spring
11. Firing Pin Stop
12. Front Sight
13. Grip Safety
14. Hammer
15. Hammer Pin
16. Hammer Strut
17. Hammer Strut Pin
18. Magazine Assembly
19. Magazine Catch
20. Magazine Catch Lock
21. Magazine Catch Spring
22. Main Spring
23. Mainspring Cap
24. Mainspring Cap Pin
25. Mainspring Housing
26. Mainspring Housing Pin
27. Mainspring Housing Pin Retainer
28. Plunger Spring Assembly
29. Plunger Spring
30. Plunger Tube
31. Rear Sight
32. Recoil Spring
33. Recoil Spring Guide
34. Recoil Spring Plug
35. Safety Lock
36. Safety Lock Plunger
37. Sear
38. Sear/Disconnector Pin
39. Sear Spring
40. Slide
41. Slide Stop
42. Slide Stop Plunger
43. Stock Assembly
44. Stock Screws
45. Stock Screw Bushing
46. Trigger

Government Safety Warnings:

WARNING

Discharging firearms in poorly ventilated areas, cleaning firearms, or handling ammunition may result in exposures to lead and other substances known to the State of California to cause birth defects, reproductive harm, and other serious physical injury. Have adequate ventilation at all times. Wash hands thoroughly after exposure.

NOTICE

If you leave a loaded firearm where a child obtains and improperly uses it, you may be fined or sent to prison or both.

Another Word About Gun Safety.....

Safe gun handling is really professional gun handling (absolutely NOT like it's done in the movies; remember, they only shoot blanks!) and it is based on good common sense.

You probably know the obvious:

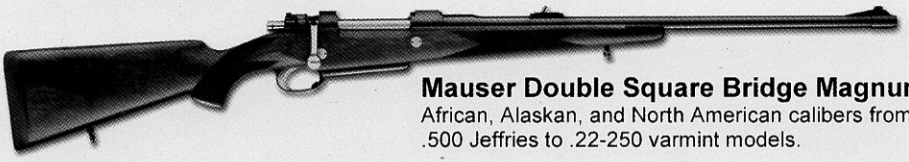
1. Always keep the pistol pointed in a safe direction.
2. Treat every gun as though it were loaded, even if you know it is not.
3. Keep your finger out of the trigger guard until you are ready to shoot.
4. Never point a gun at anything you are not willing to destroy.
5. Always know where your bullet can go, even if you hit the target (or miss it; you still must know).
6. Never put a round in the chamber until you are ready to shoot.
7. Always wear shooting glasses and hearing guards.

The Not-So-Obvious Safety Considerations:

1. Be absolutely certain you have ammunition correctly matched to the gun. The caliber markings on the gun and the caliber markings on the cartridge case head must be identical. If they are not, or you are unsure, STOP, check and if you can't be sure, DON'T USE IT. Use only ammunition of which you are certain.
2. Use only ammunition that is factory new, clean and bright; correct caliber only.
3. Never use re-loads. Use of re-loaded ammunition is risky, possibly dangerous, and voids any service obligation that we provide.
4. Be absolutely certain of your bullets' flight. These pistol cartridges are, by their nature, very powerful and particularly so, the .45 ACP. Therefore, before you shoot, you must know where your bullet will go; if you hit your target or miss it, doesn't matter; you still must know.
5. Carry/Holstering: Your pistol will fit virtually any holster that is designed for any 1911 type pistol.
    a. Never chamber a round until you are ready to shoot.
    b. If you carry your pistol in a holster (or any other way) it should be empty with an empty magazine in place with the hammer full down.
    c. If you have cartridges in the magazine, make certain the chamber is empty and the hammer is full down. (It is easy to learn to quickly chamber a round when you are ready.)
6. Before loading your pistol, be certain the barrel is clean and unobstructed. If it is obstructed in any way, even with excessive grease or oil, clean it out. Don't think you can shoot it out, because you can't; what you will do is ruin a perfectly good barrel and that is expensive (and dangerous, to you and others around you.)
7. Shoot only when you are bright, alert and fit. If you are tired, sleepy, boozy or distracted, you will not perform up to the standards of your pistol; forget shooting and come back another day.
8. Be sure you wear your shooting glasses and hearing guards, of course, but instruct others around you to do the same; in fact, insist they do so, or don't shoot.
9. Don't be in a hurry; your pistol will last a lifetime no matter how much you shoot.
10. Remember, shooting is a sporting endeavor, so have fun.

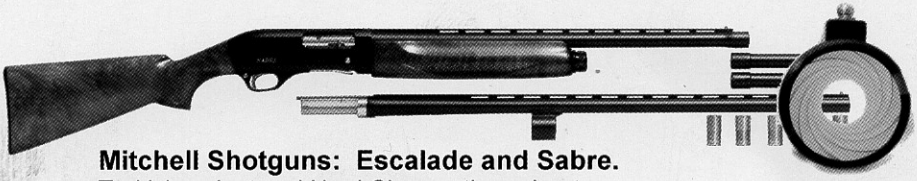
Mitchell's Mausers

Other Mitchell Products:



Mauser Double Square Bridge Magnum
African, Alaskan, and North American calibers from .500 Jeffries to .22-250 varmint models.

Black Arrow Long-Range Target Rifle
Mauser Action, Clip-fed, Striker-fired, .50BMG Mauser System in current military service.
A "Mauser on Steroids"



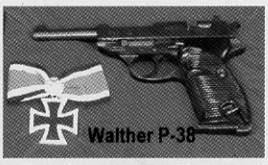
Mitchell Shotguns: Escalade and Sabre.
Turkish walnut and Hard Chrome throughout.

K98 Series WWII Era Mauser Rifles
Collector grades still in Original Military-New Condition with Original Accessories.

Presentation Grade Historical German Pistols from the time of the Great Wars, WWI, WWII and the special period between the wars.

Mauser C-96 "Broomhandle"

Luger P-08



Walther P-38

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